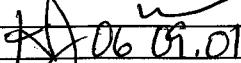


Date: Friday, 9/1/2006 12:06:53 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: NUT PLATE ASSEMBLY
Job Number	: 28387		
Estimate Number	: 11053		
P.O. Number	: N/A	Part Number	: D2873043
This Issue	: 9/1/2006 S.O. No. : N/A	Drawing Number	: D2873 REVA
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 28075	Material	: N/A
Written By	:	Due Date	: 9/15/2006 Qty: 30 Um: Each
Checked & Approved By	:  06/09/01		
Comment	: Est A05.09.13 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0375X01000	6061T6 BAR 
		Comment: Qty.: 0.3237 f(s)/Unit Total : 9.7115 f(s) 6061T6 BAR Material: 6061-T6 Bar (QQ-A-200/8 or QQ-A-225/8) (M6061T6B0.375x01.000) Identify for D2873-3 Batch: M6061T6B0375X01000
2.0	BAND SAW	BAND SAW 
		Comment: BAND SAW Cut blanks: 1.000" x 0.375" x 3.700" long
3.0	HAAS1	.HAAS CNC VERTICAL MACHINING #1 
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA and Dwg D2873 Identify as D2873-3 Dwg Rev A Folio Rev AA
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06/09/13

J.F. / 06/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:06:53 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 28387

Part Number: D2873043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SD 06.09.14

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1-Deburr
- 2- C-sink as per Dwg D2873

FF 06-09-25

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

STB 02/09/25

8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FF 06.09.27

9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT CHEMICAL CONVERSION

11/06/09/27(30)

10.0	MS20426AD46	Rivet
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 180.0000 Each(s) 100

Rivet

Pick;

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

6	MS20426AD4-6	Rivet	M 29.30
---	--------------	-------	---------

FF 06-09-28

11.0	MS21075L5	Nut Plate
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 90.0000 Each(s) 90

Nut Plate

Pick;

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

3	MS21075L5	Nut Plate	M 10/136
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FF 06-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/10/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/1/2006 12:06:53 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE ASSEMBLY

Job Number: 28387

Part Number: D2873043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2873

2-Identify as D2873-043

FF 06-09-28

30

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/06

30

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

S1391

06/10/06

30



15.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/10/06

Job Completion



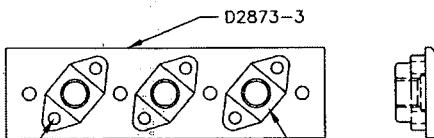
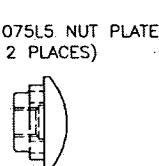
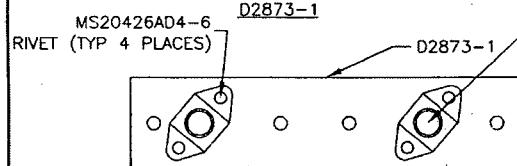
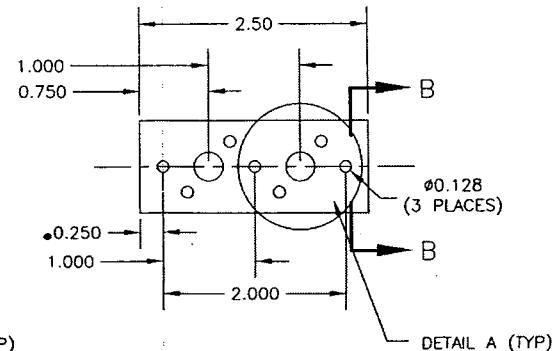
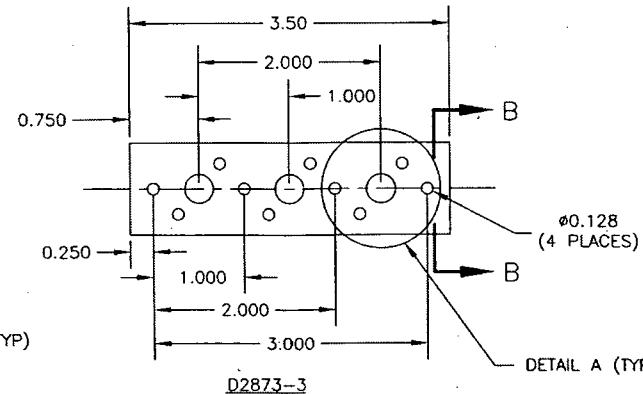
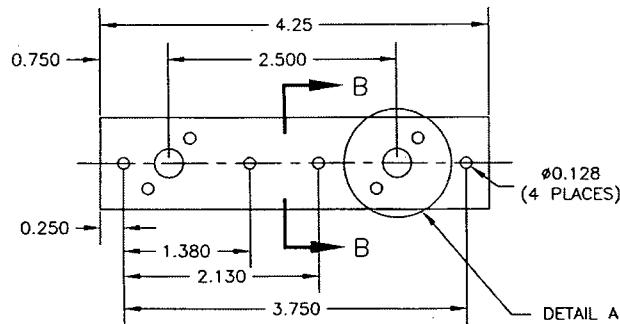
06.10.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2873-1/-3/-5 RADIUS BLOCK

- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6)  $\phi 0.128$  PILOT + C'BORE CURVED SIDE  $\phi 0.230 \times 0.125$  DEEP + C'SINK CURVED SIDE  $\phi 0.225 \times 100'$

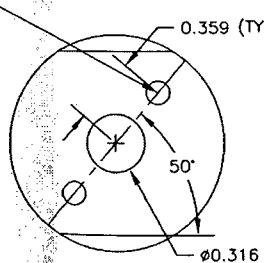
D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

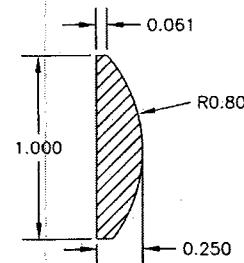
-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
	X		D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
1			D2873-3	RADIUS BLOCK
1			D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

NO. 2838  
WORK ORDER  
7

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WITHOUT NOTICE



DETAIL A (SCALE 2:5)



SECTION B-B (SCALE 2:5)

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	REV. A SHEET 1 OF 1 TITLE RADIUS BLOCK SCALE 4:5	

DART AEROSPACE LTD	Work Order:	28387
Description: RADIUS BLOCK	Part Number:	D2873-3
Inspection Dwg: D2873, Rev: A		Page 1 of 1

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      ✎ Prototype

Measured by:	<i>JNL</i>	Audited by:	<i>SP</i>	Prototype Approval:	
Date:	06/09/13	Date:	06/09/13	Date:	

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	